

Date: Tuesday, 24/06/2008 1:19:43 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: D-PAD FACE		
Job Number	: 40035		Part Number	: PB6743001189		
Estimate Number	: 13389		Drawing Number	: B67-43001 P.25		
P.O. Number	:		Project Number	: N/A		
This Issue	: 24/06/2008	S.O. No. :	Drawing Revision	: B1		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 01/07/2008	Qty:	30 Um: Each
Previous Run	:					
Written By	:					
Checked & Approved By	: MF 08-06-24					
Comment	: est rev A new issue 08.06.19 EC verified: DD					

Additional Product

Job Number:



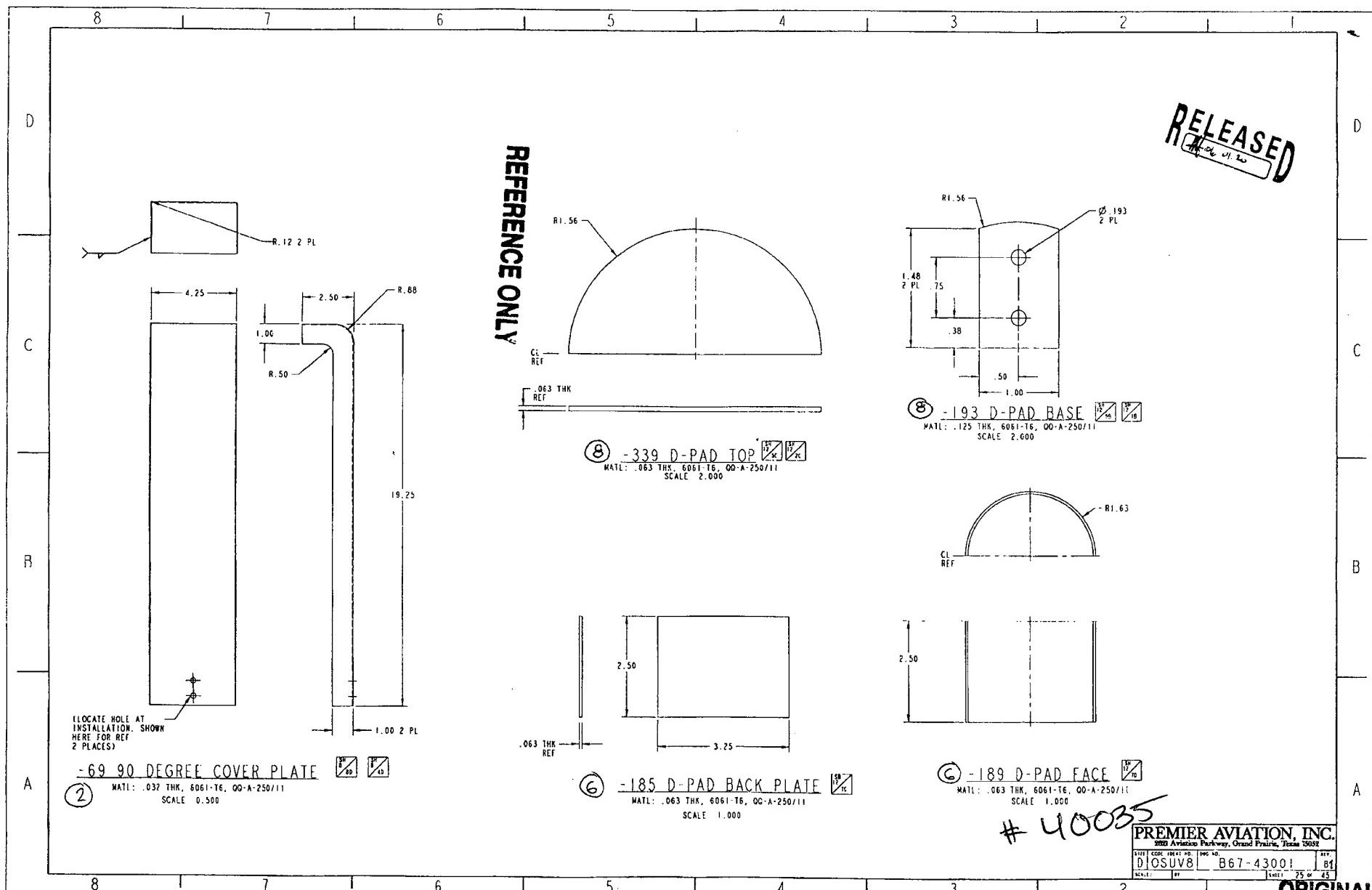
Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6063 D2914142 *	6061-T6_063_Sheet 3" Outer Tube *
Comment: Qty.: 0.0420 sf(s)/Unit Total: 1.2600 sf(s) 6061-T6_063_Sheet 3" Outer Tube * batch: B11306 * 08.06.24 ✓ 08.07.02 30		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Shear width as per dwg and roll cut to lenght 08.06.24 3-deburr * 08.07.02 30		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP * 08.07.02		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WA * 08.07.02 30		
5.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE * 08.08.19		
Job Completion 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prdg Mgr	Approval QC Inspector
08.06.24	1.0	REPLACE MG061TG5063 w/ D2914 1A2	MM	08/06/24		08.06.24	08.06.20
08.06.24	2.0	CHANGE MANUFACTURING PROCEDURE AS OUTLINED (PTO).	MM	08/06/24		08.06.24	08.06.20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			--					

NOTE: Date & initial all entries



DART AEROSPACE LTD	Work Order:	39952
Description: D-PAD FACE	Part Number:	B67-43001-189
Dwg: B67-43001 (SHEET 25)	Qty:	Page 1 of 1

Rev	Date	Change	Revised By	Approved

SPLIT

DART AEROSPACE LTD	Work Order:	23986 A
Description: Clevis	Part Number:	B67-43001-89
Dwg: B67-43001 Rev. B page 30	Qty:	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler		U 0509.08	20
2	ML	Turn as per Dwg B67-43001 Material: 6061-T6 Bar. Ø1.00 (QQ-A-200/8 or QQ-A-225/8) (M6061T6R1.000) " Identify for B67-43001-89 Issue P.O Batch: 2008449		U 0508-09	20
3	QC2	Inspect parts as they come off the machine		CJ 05/09/08	20
4	MM	Identify as B67-43001-89 Receive & Inspect		N/A	
5	QC2	Inspect parts as they come off the machine		N/A	
6	QC6	Second check Inspect Level 6		20/05-09-08	20
7	MM	Deburr if applicable		20/05-09-08	20
8	FP	Chemical Conversion Coat as per QSI 005 4.1		20/05-09-08	20
9	FP	Powder Coat Green Sandtex (Ref. 43.5.8) as per QSI 005 4.3 Mask Ø0.860"		20/05-09-08	20
10	QC3	Inspect Powder Coat		05.10.06	20
11	ST	Identify and Stock		CJ 05/10/06	5
12	AC	Cost / part: 18.16		SAC 05-10-07	5
13	DC	Close W/O 18.16 Inspect Level 21		05/10/07	5

Rev	Date	Change	Revised By	Approved
A	05.08.26	New issue	KJ/JLM	

RELEASED
15.8.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

SPLIT

DART AEROSPACE LTD	Work Order:	23986 B
Description: Clevis	Part Number:	B67-43001-89
Dwg: B67-43001 Rev. B page 30	Qty:	20

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	0509-08	20
2	ML	Turn as per Dwg B67-43001 Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8) (M6061T6R1.000) Identify for B67-43001-89 Issue P.O Batch: 2008449		Dwg Rev: M18147	
3	QC2	Inspect parts as they come off the machine Identify as B67-43001-89 Receive & inspect	CL	05/09/08	20
4	MM	Mill as per Dwg B67-43001 N/A			
5	QC2	Inspect parts as they come off the machine N/A			
6	QC2	Second check Inspect Level 6	JL	05/09/08	20
7	MM	Deburr if applicable	JL	05-09-08	20
8	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	050916	20
9	FP	Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 Mask Ø0.860"			
10	QC3	Inspect Powder Coat	IP	05.10.06	20
11	ST	Identify and Stock	CL	05/10/06	15
12	AC	Cost / part: 18.16	SC	05-10-07	15
13	DC	Close W/O 18.16 Inspect Level 21	(S)	05/10/07	15

Rev	Date	Change	Revised By	Approved
A	05.08.26	New issue	KJ/JLM	9/11

RELEASED
11/5/08 3:00